

Work Order ID 67319

Tuesday, March 15, 2011 10:16:02 AM



Page 1

Item ID: D350-636-215

Accept



Setup Start



Revision ID:

Item Name: Skidtube STD LH, Deluxe

Stop



Start Date: 3/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-03-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-215 CHG001

Suleyker

11-04-6

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1- Assemble Toe kit, Wedge kit and Tow ring kit to D350-636-015 as per IIN-D350-636

Ps 15 + 16 + 17 + 20

1 0 11/04/06

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suleyker

(X)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 67319

Tuesday, March 15, 2011 10:16:02 AM

Page 2

Item ID: D350-636-215

Accept

Revision ID:

Item Name: Skidtube STD LH, Deluxe



Start Date: 3/15/2011 Start Qty: 1.00

Required Date: 3/21/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150  Packaging | Memo Identify and pack for shipping as per PPP D350-636-215 Location: <u>23</u> PPP rev: <u>B</u> | 0.00 0.00 | | | | | | | |
| 160  QC | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Mr. 11-04-06

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Tuesday, March 15, 2011 10:16:10 AM







Parent Item: D350-636-215

Parent Item Name: Skidtube STD LH, Deluxe

Start Date: 3/15/2011**Required Date:** 3/21/2011**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D350-636-015  | | Manufactured | No | | | 110 | Each | 1.0000 | 1 | 1 | | | |
| <div> <div>67176</div> <div></div> <div>11/04/05</div> </div> | | | | | | | | | | | | | |
| <div> <div>Skidtube STD w/ Training Wearplates, LH</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div> | | | | | | | | | | | | | |
| <div> <div>FG072</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>64950</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| D350-636-101  | | Manufactured | No | | | 110 | Each | 7.0000 | 1 | 1 | | | |
| <div> <div>Toe Step, LH/RH</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div> | | | | | | | | | | | | | |
| <div> <div>FG021</div> <div>7</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>26089 67316</div> <div>7</div> <div></div> </div> | | | | | | | | | | | | | |
| D350-636-105A  | | Manufactured | No | | | 110 | Each | 5.0000 | 1 | 1 | | | |
| <div> <div>Wedge Installation</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div> | | | | | | | | | | | | | |
| <div> <div>FG021</div> <div>5</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div><u>51959</u></div> <div>2</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>54958</div> <div>3</div> <div></div> </div> | | | | | | | | | | | | | |
| D350-636-109  | | Manufactured | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| <div> <div>Tow Ring Installation</div> <div> <div>67205</div> <div></div> <div>11/04/05</div> </div> </div> | | | | | | | | | | | | | |

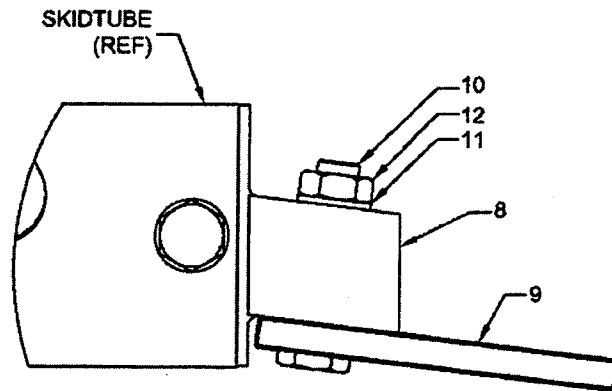
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

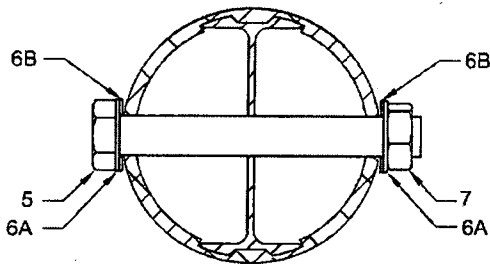
NOTE: Date & initial all entries



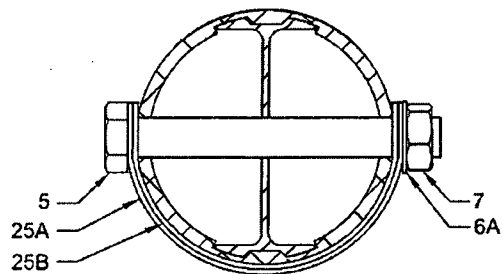
DETAIL D
1 PL PER SKIDTUBE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67319

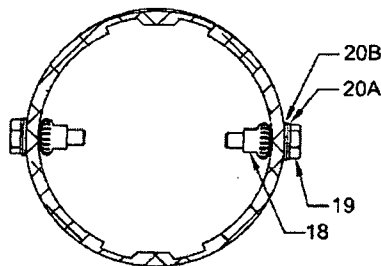
PL 11-03-25



SECTION E-E
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)



SECTION Q-Q
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION F-F
2 PL PER SKIDTUBE

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **H**
Date: 10.07.26

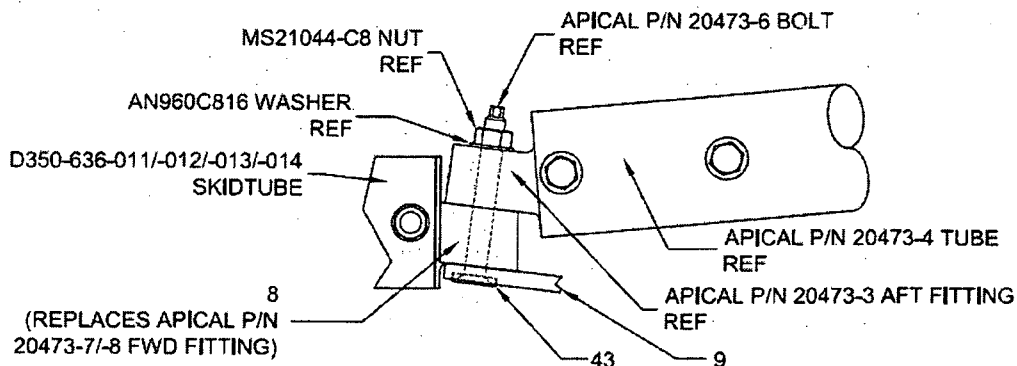
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

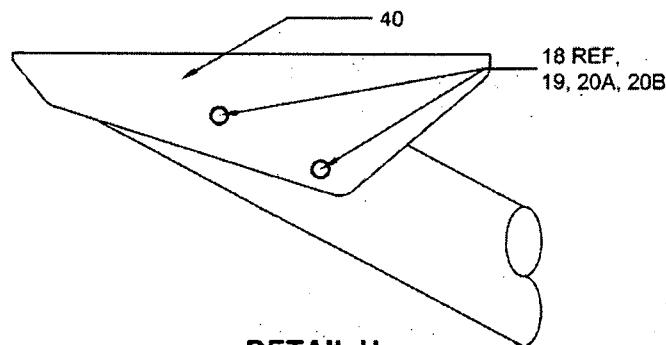
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

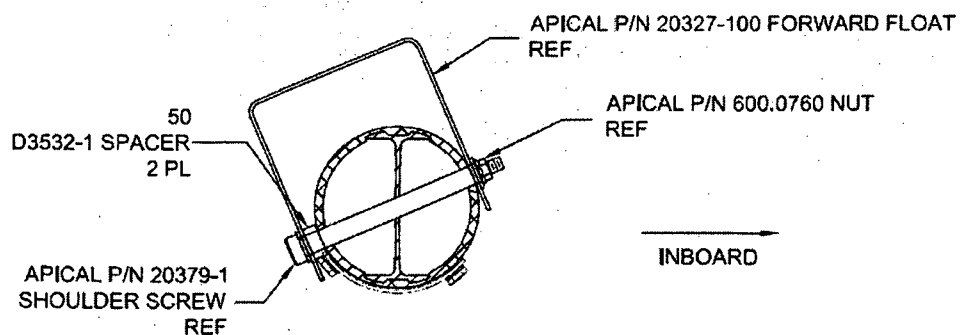
NOTE: Date & initial all entries



DETAIL G
(APICAL CYLINDRICAL AND TRI-BAG INSTALLATIONS)
1 PL PER SKIDTUBE



DETAIL H
(D350-636-101 TOE STEP)
1 PL PER SKIDTUBE



SECTION N-N
(LH SHOWN, RH OPPOSITE)
(D350-636-011/-012 WITH APICAL CYLINDRICAL FLOATS ONLY)

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **H**
Date: 10.07.26

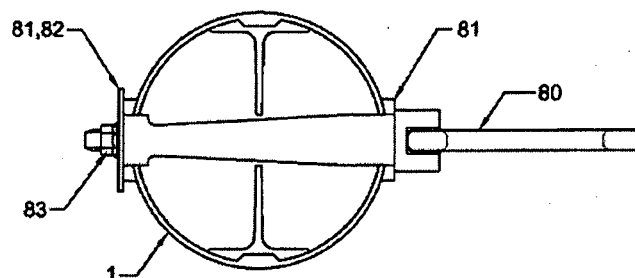
| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

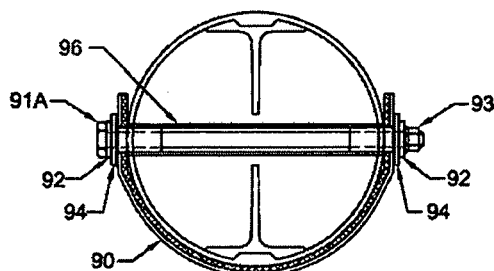
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



SECTION R-R
SHOWN WITH DRILLED Ø0.625" HOLE &
D350-636-109 TOW RING KIT

w/o 47319



SECTION S-S
D350-636-015/-016/-017/-018/-215/-216/-217/-218
SKIDTUBES, 3 PL

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **H**
Date: 10.07.26

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

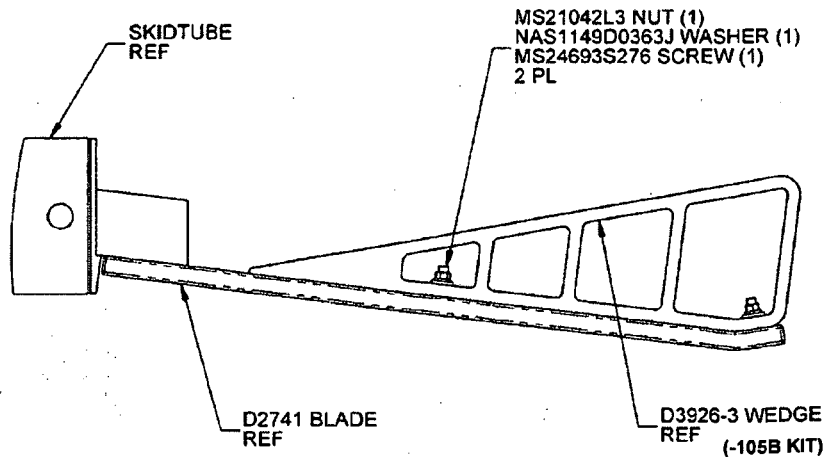
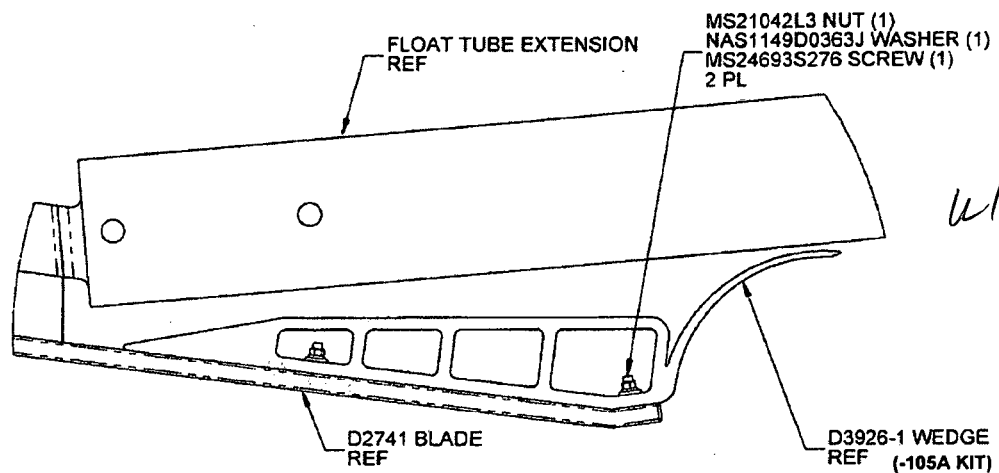
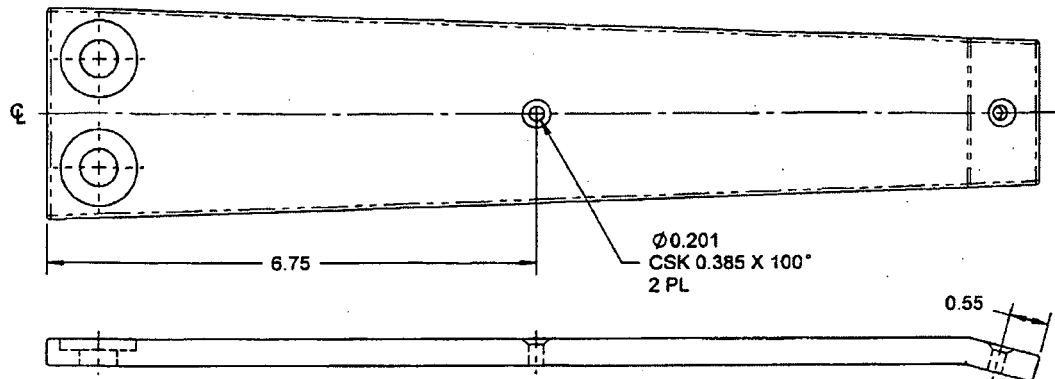


Figure 4: D350-636-105A/-105B WEDGE KIT INSTALLATION

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: H
Date: 10.07.26

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries